



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D1048
Job Sheet 178547



Part No: D1048

Job Qty: 12 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP: B 02.02.22 Re-format NG IPP Rev:C Now on Waterjet 06-12-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Waterjet		X 18/06/10
100	Waterjet	12 pcs	6/15/18	6/15/18	0.00	0.32	Waterjet1		SC 18/06/10
120	QC	12 pcs	6/15/18	6/15/18	0.00	0.00	QC8		
130	Small Fab	12 pcs	6/15/18	6/15/18	0.00	0.36	Small Fab-1		
140	Brake NC	12 pcs	6/15/18	6/15/18	0.00	0.34	Brake NC 1		DAE
150	QC	12 pcs	6/15/18	6/15/18	0.00	0.00	QC5		38
160	Powdercoat	12 pcs	6/15/18	6/15/18	0.00	0.09	Powdercoat4		BL 18-06-10
170	QC	12 pcs	6/15/18	6/15/18	0.00	0.00	QC3		38
180	Packaging	12 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1	6A/20	JUN 27 2018
190	QC21-SA	12 Ea	6/15/18	6/15/18	0.00	0.00	QC21		DAE

Part Op 100 - 1-Cut as per Dwg D1048 Prog Rev: 1

Descriptions: 130 - 1-Debur if required. Break all sharp corners .010 / .020 as per dwg.

140 - Form as per dwg using DT10143

160 - START TIME: 2:20 OVEN TEMPERATURE: 300 FINISH TIME: 2:30

M 138700

21 JUN 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2160 sf (.018 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	135	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches $\pm$ 0.010	0.760 0.740	0.753	
2	Clamp	2.175Inches $\pm$ 0.010	2.185 2.165	2.174	
3	Clamp	1.755Inches $\pm$ 0.010	1.765 1.745	1.752	
4	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365	0.374	

5

Clamp

0.203Inches + 0.005
- 0.001

0.208
0.202

0.204

Diameter

Plex 6/1/18 1:43 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								